



Empress of the North

Temporary Repair Plan

(Prior to transit from AK to OR)

Stem Damage

- Stem area damage shall be cropped and inserted. Original scantlings to be matched. Insert area and repairs to be to the satisfaction of the attending ABS Surveyor.

No. 2 Starboard Fuel Tank

- Damaged fuel tank (located from Frame 37 to 53) to be cropped and inserted as original including area of damaged chine. Insert area and repairs to be to the satisfaction of the attending ABS Surveyor.

Void No. 1

- Flat Keel Damage – Area 6' aft of Frame 53 to be doubled with 3/8" plate, and watertight integrity restored.
- Chine Damage – Chine damage in way of Frame 73 (boundary to Void No. 2) to be doubled with 3/8" plate and watertight integrity restored.
- Bulkhead at Frame 53 – Bulkhead inserted to restore watertight integrity.
- Tripped Floors – Temporary stanchions (6" diameter schedule 40 steel pipe with 3/8" flat plate cap) installed between underside of Potable Water Tank and 3/4" hull plating.

Void No. 2

- Chine Damage – Chine damage in way of Frame 73 (boundary to Void No. 1) to be doubled with 3/8" plate and watertight integrity restored.
- Tripped Floors – Temporary stanchions (6" diameter schedule 40 steel pipe with 3/8" flat plate cap) installed between underside of Potable Water Tank and 3/4" hull plating.
- Bulkhead at Frame 73 – Bulkhead inserted to restore watertight integrity.

Void No. 3

- Bulkhead at Frame 89 – Bulkhead inserted to restore watertight integrity.

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- Tripped Floors – Temporary stanchions (6" diameter schedule 40 steel pipe with 3/8" flat plate cap) installed between underside of Sewage Tank and 3/4" hull plating.
- Flat Keel Damage – Area adjacent to Frame 99 to be doubled with 3/8" plate, and watertight integrity restored.

Void No. 4

- Bulkhead – Bulkhead at Frame 109 to be inserted to restore watertight integrity.



Centre line girder and frames fitted and being welded on the Stem.

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Bulkhd insert fitted on Frm 37 between FO and Ballast tanks. Additional stiffening will be fitted to support badly depressed bottom plate iwo of frames 43 and 39.



20 pieces of Pipe stays made and fitted between the bottom plate and the Suspended FW tanks iwo of fuel oil tank and Void 1, between port and Stbd longi girder. More are being fitted.

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Bottom plate inserted at the Chine between Frms 57-53, 53-46 and 37-30



Doubler welding on the aft Chine damage, Frm 69-80 completed.

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New frames and flat Bar longis fitted in Fwd Chine damage, Fr.30-57



Bottom Plate ready to be fitted in place tonight between Fr 53-57.

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Fwd Stem Bar positioned and internals being prepared.



B Strake plate cut out between Fr. 43-51

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Fwd Chine plates between frms 28 and 57 fully cut out, including the plate in B strake between Fr.43 and 51.



Doubling plate put on the Chine iwo of Fr 69 and 78

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Doublers put in place on KP between frms 55 and 61.



Doubler on Strake B between Frms 107 and 99 iwo void 3.

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